

Work Order ID 72896

Wednesday, August 17, 2011 2:46:30 PM



Page 1

Item ID: D4271-025

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *M*

Date: *11/08/11*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4271

D

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4271
REAM HOLE AS PER DWG
CUT RIVET AT 1.130"
C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD

EB 11/08/26 *(D)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

EB 11/08/26

(H)

120

Identify as per dwg & Stock Location: *G.A*

0.00



Packaging

Memo

0.00

Packaging

w/o 72895

EB 11/08/26 *(D)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72896

Page 2

Wednesday, August 17, 2011 2:46:31 PM

Item ID: D4271-025

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11.08.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:46:36 PM

Page 1

Work Order ID: 72896

Parent Item: D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.20 new issue EC veriufied by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4149-5		Manufactured	No			100	Each	7.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Eyebolt Stud

Location

Loc Qty

Loc Code

ST133

7

68871

7

D4419-1		Manufactured	No			100	Each	2.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Fwd Support Plate

Location

Loc Qty

Loc Code

ST

2

72506

2

D4281-1		Manufactured	No			100	Each	20.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Spacer

Location

Loc Qty

Loc Code

ST139

20

66705

1

71930

19

D4281-3		- Manufactured	No			100	Each	10.0000	1	1			
---------	--	----------------	----	--	--	-----	------	---------	---	---	--	--	--



Spacer

Location

Loc Qty

Loc Code

ST139C

10

72666

6

72684

4

8/11/08/25

8/11/08/26

B 73051 (24)

8/11/08/26

8/11/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:46:36 PM

Page 2

Work Order ID: 72896

Parent Item: D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No
BOLT



100 Each 49.0000



2

Location

Loc Qty

Loc Code

ST357

49

117793

3

118451

46

MS20427M4-20 Purchased No
RIVET



100 Each 184.0000



1

Location

Loc Qty

Loc Code

ST318

184

118429

184

MS20615-4M18 Purchased No
Rivet



100 Each 622.0000



10

Location

Loc Qty

Loc Code

ST323

622

117411

67

118077

370

118543

185

MS21043-4 Purchased No
Nut



100 Each 939.0000



2

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

899

117793

482

118378

417

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:46:36 PM

Page 3

Work Order ID: 72896

Parent Item: D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,636.000

4

4



Washer



Handwritten signature and date: 8/17/08/26

Location

Loc Qty

Loc Code

ST297

4636

116900

18

117291

4618

4

Wednesday, August 17, 2011 2:46:36 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

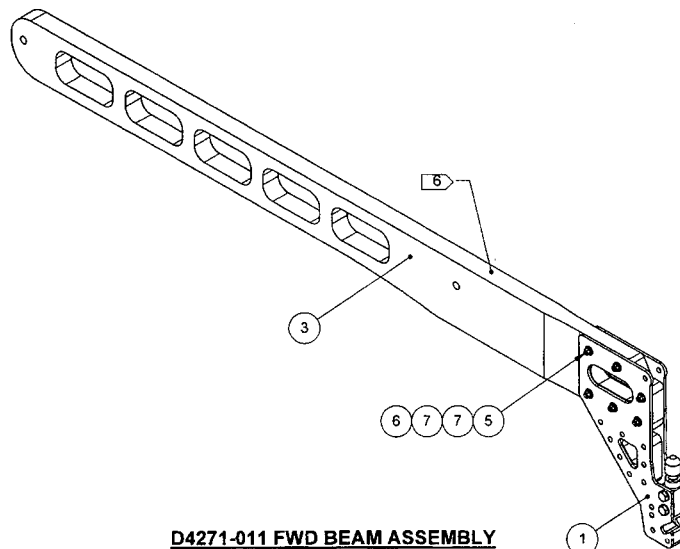
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

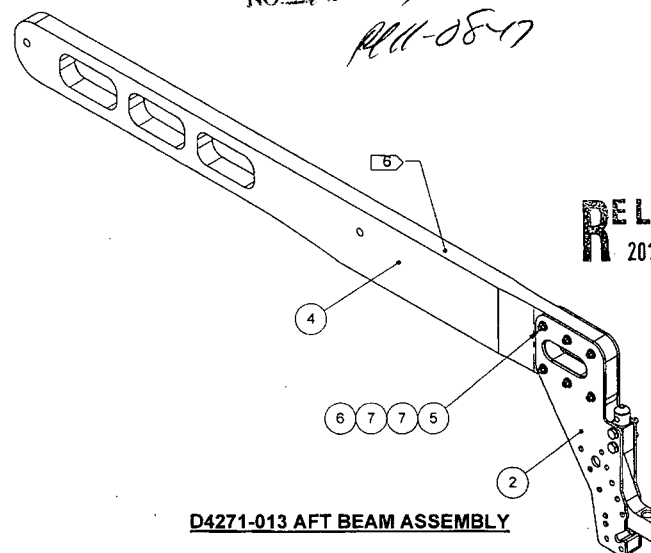
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72856

REV-08-17

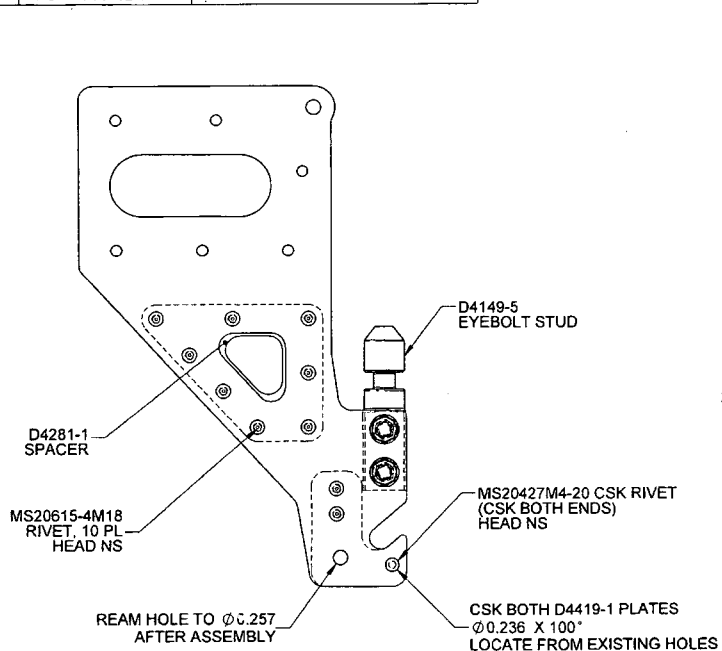
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2011-07-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR O.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JD	DRAWING NO.	REV. D
MFG. APPR.	E	D4271	SHEET 1 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

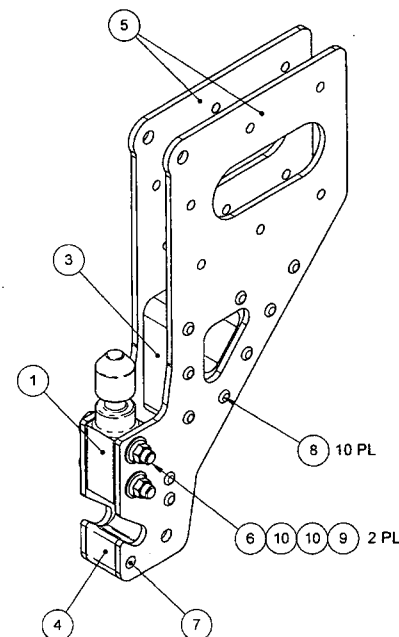
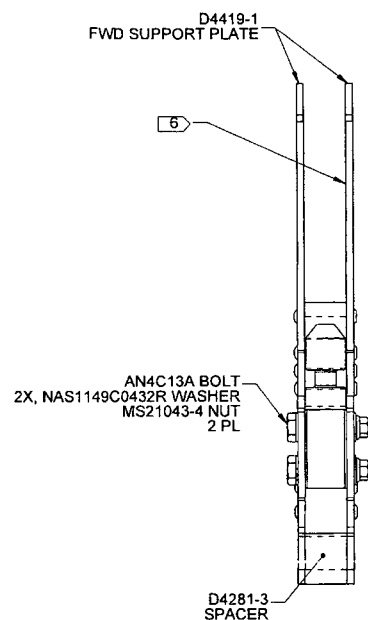
ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



D4271-025 FWD BEAM END FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs



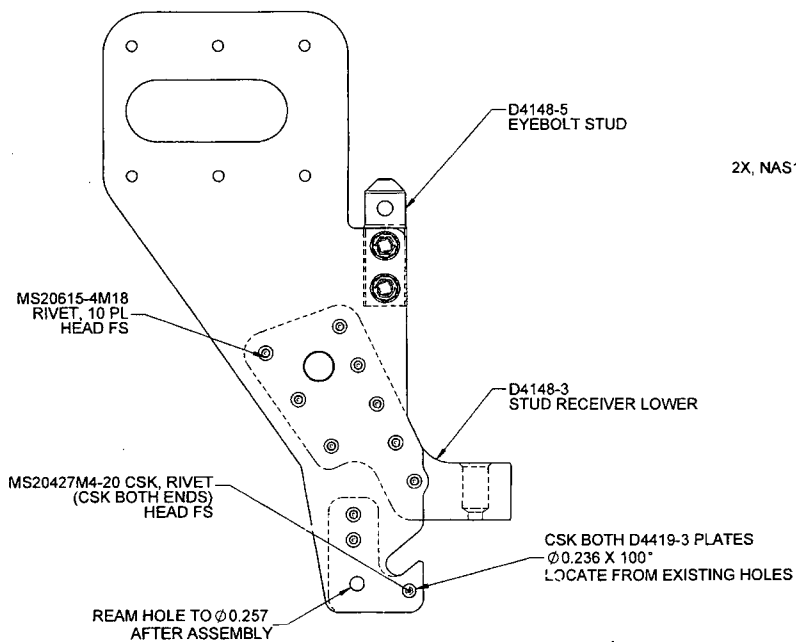
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72894

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4271	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BEAM ASSEMBLIES	
DATE	11.07.14	NTS	

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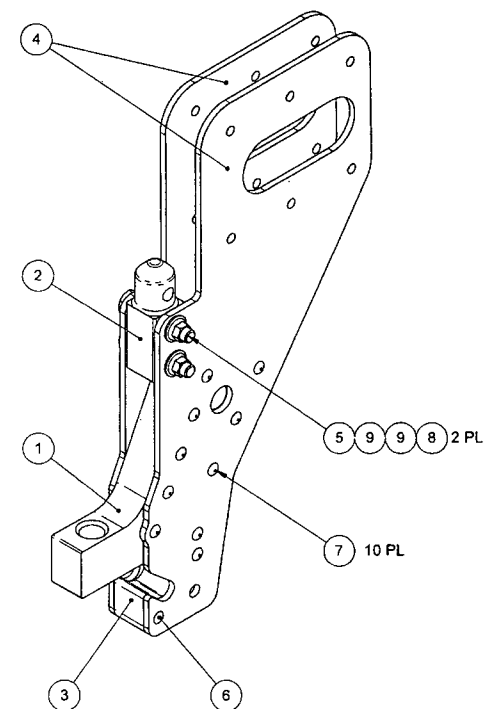
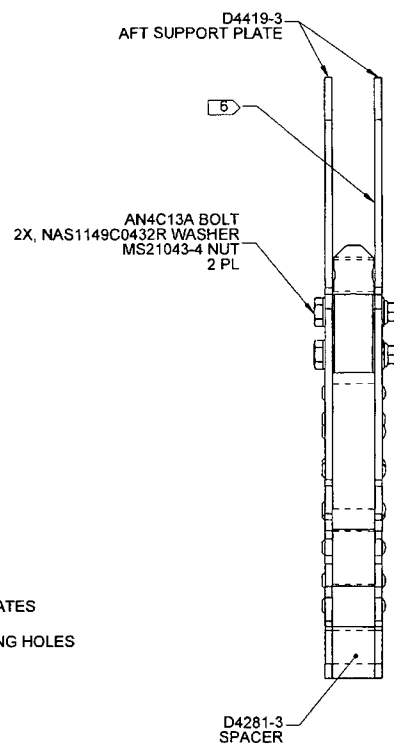
ITEM	QTY .027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



D4271-027 AFT BEAM END FITTING ASSEMBLY D

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART CS: 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



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